

Date: Wednesday, 03/06/2009 10:48:41 AM
 User: Julie Dawson

Process Sheet

| | | | |
|------------------------------------|--|---------------------------|------------------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | LID PRO ARM ASSEMBLY (SHORT) |
| Job Number : | 48351 | | |
| Estimate Number : | 10258 | | |
| P.O. Number : | | Part Number : | D2332041 |
| This Issue : | 03/06/2009 | Drawing Number : | D2332 |
| Prsht Rev. : | NC | Project Number : | N/A |
| First Issue : | // | Drawing Revision : | EC1 |
| Previous Run : | 46430 | Material : | |
| Written By : | | Due Date : | 15/06/2009 |
| Checked & Approved By : | JUD09.00.03 | | |
| Comment : | Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/ RF Est Rev:C 08-06-02 add comment DD verified by:EC | | |

Qty: 10 Um: Each

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TR1000W049 | 304 RD Tube 1.00 x .049W |
|-----|----------------|--------------------------|



Comment: Qty.: 0.4331 f(s)/Unit Total : 4.3313 f(s)

Material: 1.000" OD x 0.049" wall SS Tube (Seamless)

Batch M11145740

M108756

Batch

EP09/06/10

| | | |
|-----|----------|-----------------------|
| 2.0 | M304R250 | 304 SS Round bar .250 |
|-----|----------|-----------------------|



Comment: Qty.: 0.1092 f(s)/Unit Total : 1.0920 f(s)

Material: Ø0.250" 304SS Rod

Batch M107109

EP09/06/10

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

3-Deburr

| | | |
|-----|----------------|--------------------------|
| 4.0 | M304TR0500W035 | 304 RD Tube .500 x .035W |
|-----|----------------|--------------------------|



Comment: Qty.: 1.2502 f(s)/Unit Total : 12.5020 f(s)

304 RD Tube .500 x .035W

M111704

EP09/06/10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

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Part Number: D2332041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012
(Note: Make (2) D2332-11 Prop Arms per assembly.)

SR 02/06/16 (10)

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. (Drill 1 per assembly)
2-ensure no foreign objects inside fo tube and deburr

SR 02/06/16

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

D2332-5 }
D2332-7 }
D2332-11 }
D2332-1 }
09/06/16 (410)

09/06/16 (410)

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8296. (Weld 1 per assembly)
***** insure nothing is inside of tube before welding*****

Mon 06/17

A/R SS Rod Batch: M106762
*****brush weld right after welding, to take color off*****

09.06.17

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.06.17

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/06/18 (410)

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble B 9-6-19
2-Assemble as per Dwg D2332

09/06/22 (10)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Job Number: 48351

Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN4-4A

Bolt

M1108138

09/06/22

13.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 30.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN960JD416L

Washer

M110153

09/06/22

14.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 MS21042L4

Nut (or -4)

M110507

09/06/22

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/06/22 (10)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 512

9/6/22

510

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/22

Job Completion



MF
09-06-22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

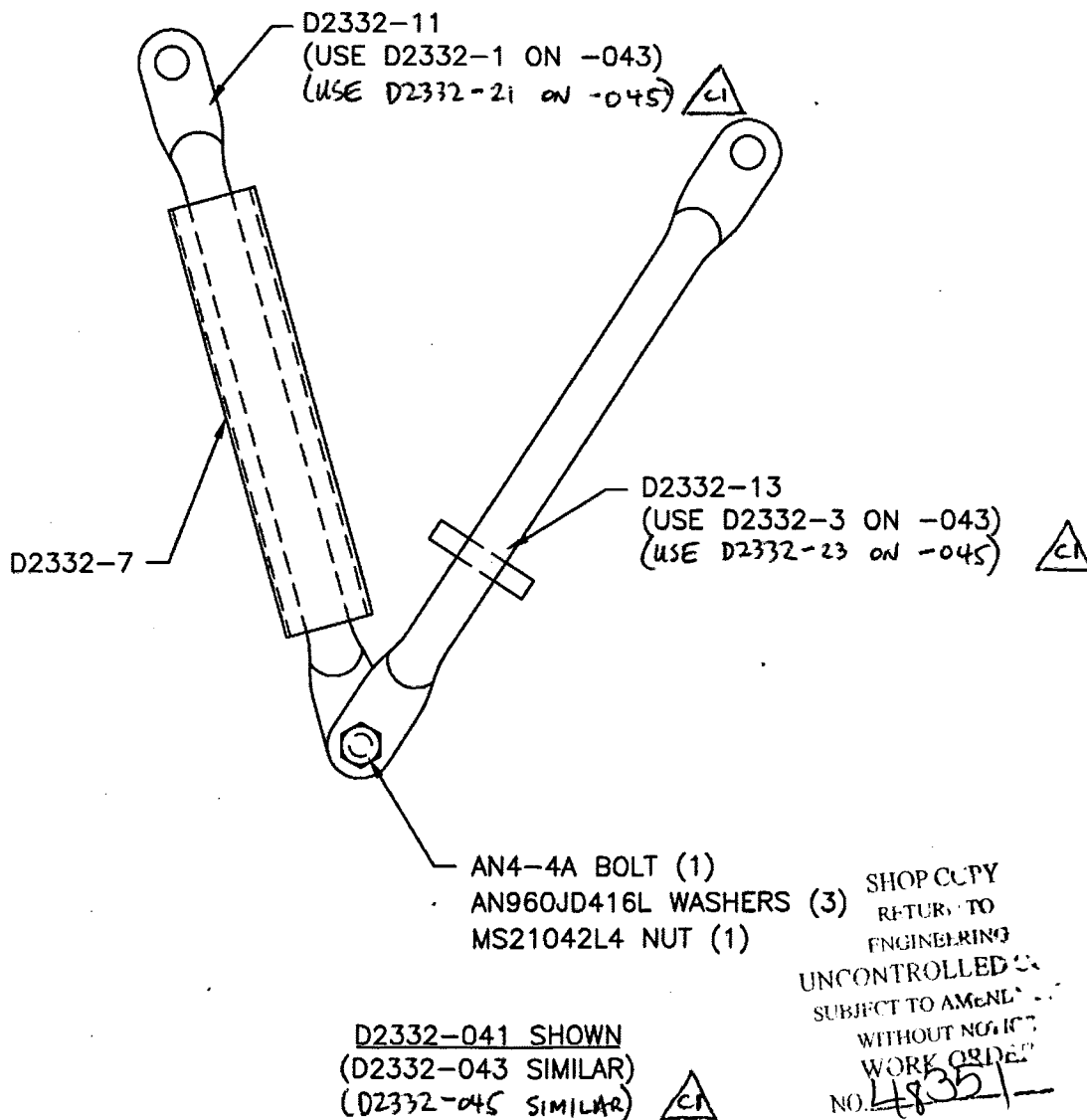
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART

| | | | |
|------------------|----------|---|------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D2332 | REV. C SHEET 1 OF 2 |
| DATE 03.07.03 | | TITLE LOD PROP ASSEMBLY | SCALE NTS |
| A | 94.12.16 | NEW ISSUE | |
| B | 97.09.30 | CHANGE 416 WASHERS TO 416L | |
| C | 03.07.03 | MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.) | |
| C1 | 03.08.06 | ADD -045 PROP (7.25" LONG) | |

RELEASED
03.07.04 

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NO. 48351

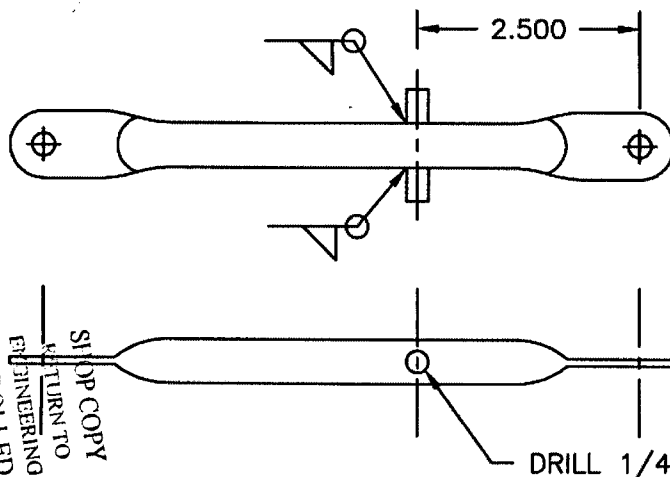
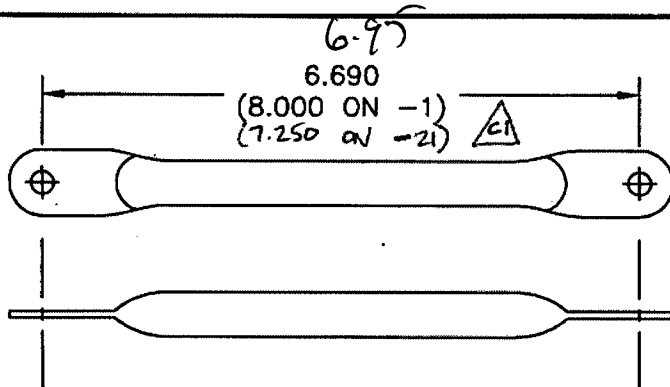
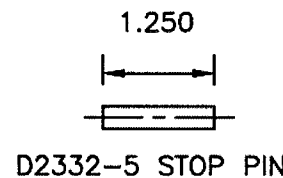
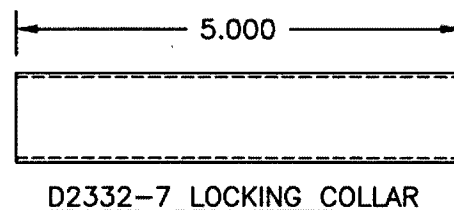
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DART



| DESIGN | DRAWN BY | TITLE | REV. C |
|----------|----------|---|--------------|
| # | # | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | SHEET 2 OF 2 |
| # | # | D2332 | |
| DATE | | LID PROP ASSEMBLY | SCALE |
| 03.07.03 | | | 1:2 |
| C | 03.07.03 | MAKE - 041 PROP 6.69" LONG (STD) | |
| C1 | 03.08.06 | MAKE - 043 PROP 8.00" LONG (ORT) | |
| | | ADD - 045 PROP 7.25" LONG | |



D2332-13
M/F D2332-11 & D2332-5
(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.07.04

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